

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019634**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**WELDING**

This QA Inspector observed the following work in progress:

**BAY 14**

This QA Inspector observed ZPMC qualified welding personnel identified as 066459 perform welding by Shielded Metal Arc Welding (SMAW), on deck panel DP3152 to deck panel DP3153 joint of OBG Segment 13CW. Weld joint is identified as SA3232-001-002. ZPMC Quality Control (QC) Inspector identified as Zheng Zhi Wei was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-B-U2b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 045280 perform welding by Flux Cored Arc Welding (FCAW), on stiffener to floor beam joint of OBG Segment 13AW. Weld joint is identified as SEG3013AU-099. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067876 perform welding by Flux Cored Arc Welding (FCAW), on stiffener to floor beam joint of OBG Segment 13AW. Weld joint is identified as

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SEG3013AU-104. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066163 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013V-345. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and weld repair report B-WR20129. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 067876 perform welding by Flux Cored Arc Welding (FCAW), on bottom plate stiffener to stiffener joint of OBG Segment 13AW. Weld joint is identified as SEG3013AV-085. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 037840 perform welding by Shielded Metal Arc Welding (SMAW), on stiffener to longitudinal diaphragm joint of OBG Segment 13BW. Weld joint is identified as SEG3014L-148, 152. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Upadhye, Anand

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer